

ASAP!

# Work Order ID 66639

Wednesday, February 23, 2011 11:18:39 AM

~~PRELIMINARY ISSUE~~

Accept

Item ID: D4319-3

Revision ID: PRELIM

Item Name: Spacer

Start Date: 2/23/2011 Start Qty: 1.00

Required Date: 2/23/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4319

PA4

A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D4319

Dwg Rev: PA1

Prog Rev: PA1

6061 . 188

Deburr if required

1811-2-23

(3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1811-2-23

[illegible]

Wednesday, February 23, 2011 11:18:39 AM

**Accept**

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**Setup Start**

**Stop**

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**Cust Item ID:**

**Required Date: 2/23/2011      Req'd Qty: 1.00**

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Stop**

**Insp.  
Stamp**

0.00 - inspected to P44

[REDACTED]

QC

## Memo

0.00

## Quality Control

Day only  
Jul 02/23 (X3)

0.00

[illegible]

HandFinish

## Memo

0.00

## Hand Finishing

x3   0   90   11   02   23

0.00



**Powdercoat**

## Memo

0.00

## Powder Coating

START TIME: 8:00  
OVEN TEMPERATURE: 320°  
FINISH TIME: 8:50

3 BR 11-2-24.

**Work Order ID 66639**

Wednesday, February 23, 2011 11:18:39 AM



Page 3

Item ID: D4319-3

Revision ID: PRELIM

Item Name: Spacer

Start Date: 2/23/2011 Start Qty: 1.00

Required Date: 2/23/2011 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				3	0	11/02/24	
170  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00  0.00				11/3/12		(32)	
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00						11/03/03	

COFC only  
NON AIRWORTHY  
PART

POSITIVE RECALL

EFFECTIVE 11/02/23 AUTH   
RELEASED DATE 11/03/03

# Picklist Print

Wednesday, February 23, 2011 11:18:36 AM

Page 1

Work Order ID: 66639



Parent Item: D4319-3



Parent Item Name: Spacer



Start Date: 2/23/2011

Required Date: 2/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: lpp revA 11.02.23 new Issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.188 		Purchased	No				sf	36.2000		0.029474			
6061-T6 .188 Sheet													

Bil-2-23

Location

Loc Qty

Loc Code

MAT

36.2

110993

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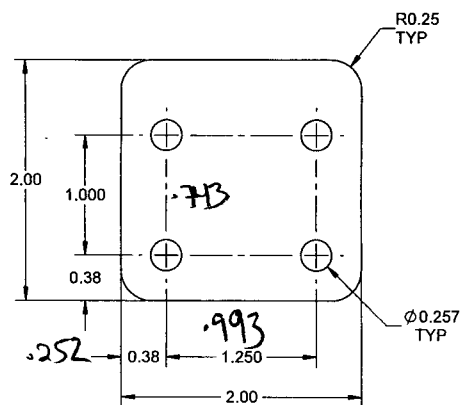
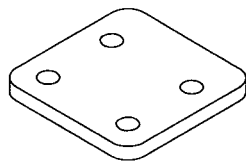
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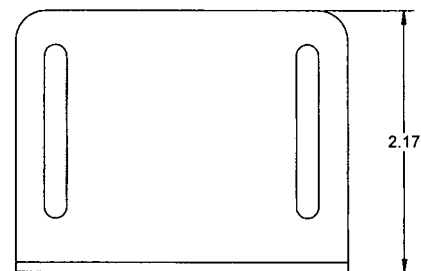
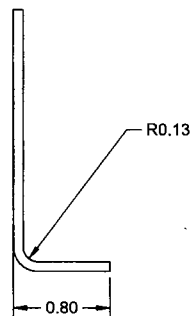
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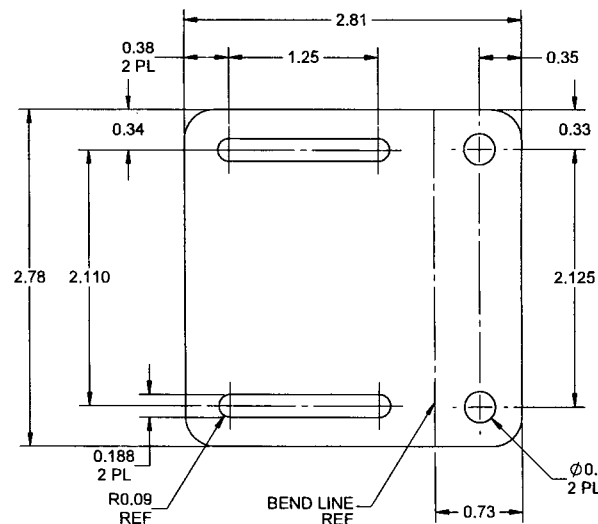
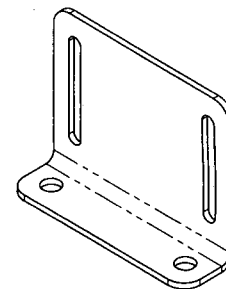




**D4319-3 SPACER**



**D4319-5 GPS BRACKET**



**D4319-5F FLAT PATTERN**

**PRELIMINARY A4**  
11.02.22 (AJS)

**NOTES:**

- 1) MATERIAL -3: 6061-T6/T62 ALUMINUM SHEET 0.188 THICK PER QQ-A-250/3 OR AMS QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.188)  
-5: MAKE FROM -5F  
-5F: 6061-T6/T62 ALUMINUM SHEET 0.080 THICK PER QQ-A-250/3 OR AMS QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4319-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -3: 0.07 lbs  
-5: 0.02 lbs

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. <b>D4319</b>	REV. PA4
MFG. APPR.		TITLE <b>BRACKETS</b>	SHEET 2 OF 2
APPROVED			SCALE NTS
DE APPR.			
DATE	11.02.03	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

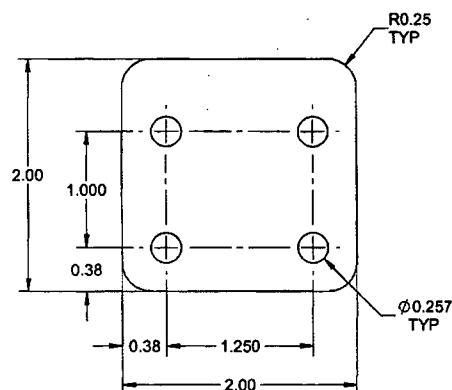
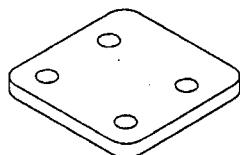
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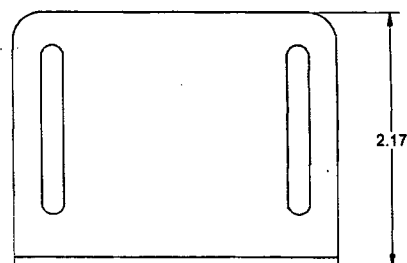
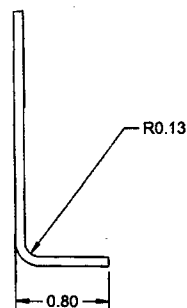
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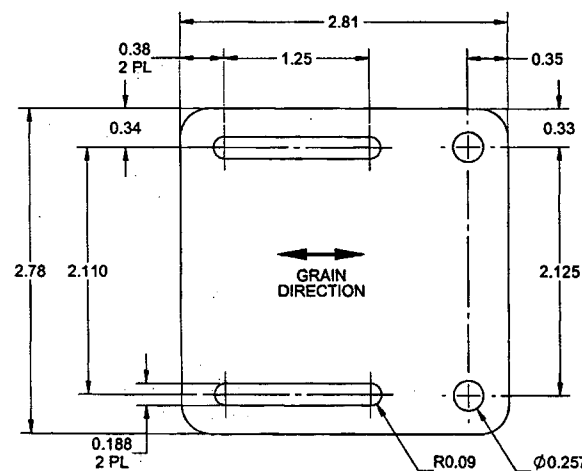
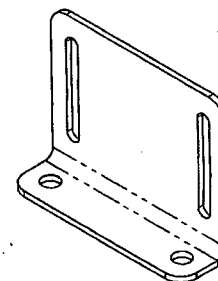
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**D4319-3 SPACER**



**D4319-5 GPS BRACKET**



**D4319-5F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL -3: 6061-T6/T62 ALUMINUM SHEET 0.188 THICK PER QQ-A-250/3 OR AMS QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.188)
- 5: MAKE FROM -5F
- 5F: 6061-T6/T62 ALUMINUM SHEET 0.080 THICK PER QQ-A-250/3 OR AMS QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4319-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -3: 0.07 lbs  
-5: 0.02 lbs

66639

**RELEASED**  
R 2011-03-03  
JMB

DESIGN	ME	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4319</b>	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BRACKETS</b>	NTS
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8 7 6 5 4 3 2 1